

12

Date: Tuesday, 2/26/2008 7:59:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT LH
Job Number : 37602	
Estimate Number : 12336	
P.O. Number :	Part Number : D206555007
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D206-555 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 32909	Material :
Written By : <u>JA 08 02 26</u>	Due Date : 3/22/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JA 08 02 26</u>	
Comment : Est: C 99.03.23 Returned to Electro Polish DM	
Est Rev:D Now on WaterJet 07-06-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
 Type Labels as per PPP D206-555-007

2.0	M304S25GA	304/316 .020" Sheet
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PTU

Comment: Qty.: 0.4410 sf(s)/Unit Total : 4.4100 sf(s)
 304/316 .020" Sheet
 Batch: 106236 B 8-3-5

16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-3-5

Comment: INSPECT PARTS AS THEY COME OFF MACHINE DEBURR B 8-3-5

4.0	QC8	SECOND CHECK
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PTU

Comment: SECOND CHECK 08/03/05 (x16)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7
 Finish form on bench forming Jig DT8321-7
 Remove tooling tabs and deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
080305	20	25 ga not available.						

Part No: D206555-007 PAR #: N/A Fault Category: Engineering NCR: Yes No DQA: AD Date: 08/04/04
 QA: N/C Closed: _____ Date: _____

NCR: <u>37602</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080805	20	25 ga not available. \$	<i>[Signature]</i> 08/14/02	Acceptable to use 24 ga @ 0.022" thick material.	<i>[Signature]</i> 08/03/05	<i>[Signature]</i> 08/03/05	<i>[Signature]</i> 08/03/05	<i>[Signature]</i> 08/03/05
080102	40	Parts to be discontinued and quarantined per NCR 241	<i>[Signature]</i> 08/14/02	Parts to go to engineering for further investigation. per NCR 241	<i>[Signature]</i> 08/04/02	<i>[Signature]</i> 08/04/02	<i>[Signature]</i> 08/04/02	<i>[Signature]</i> 08/04/02

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 7:59:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 37602

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

OUTSIDE SERV 20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O: _____

Possible supplier: TQF Technologies

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



UMF

08-08-02

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN JB	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C SHEET 1 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE NTS
A	89.06.08	NEW ISSUE	
B	98.10.26	RE-DRAWN ADDED D206-555-011/-012/-045	
C	06.09.01	REVISED FINISH PER NCR 016	

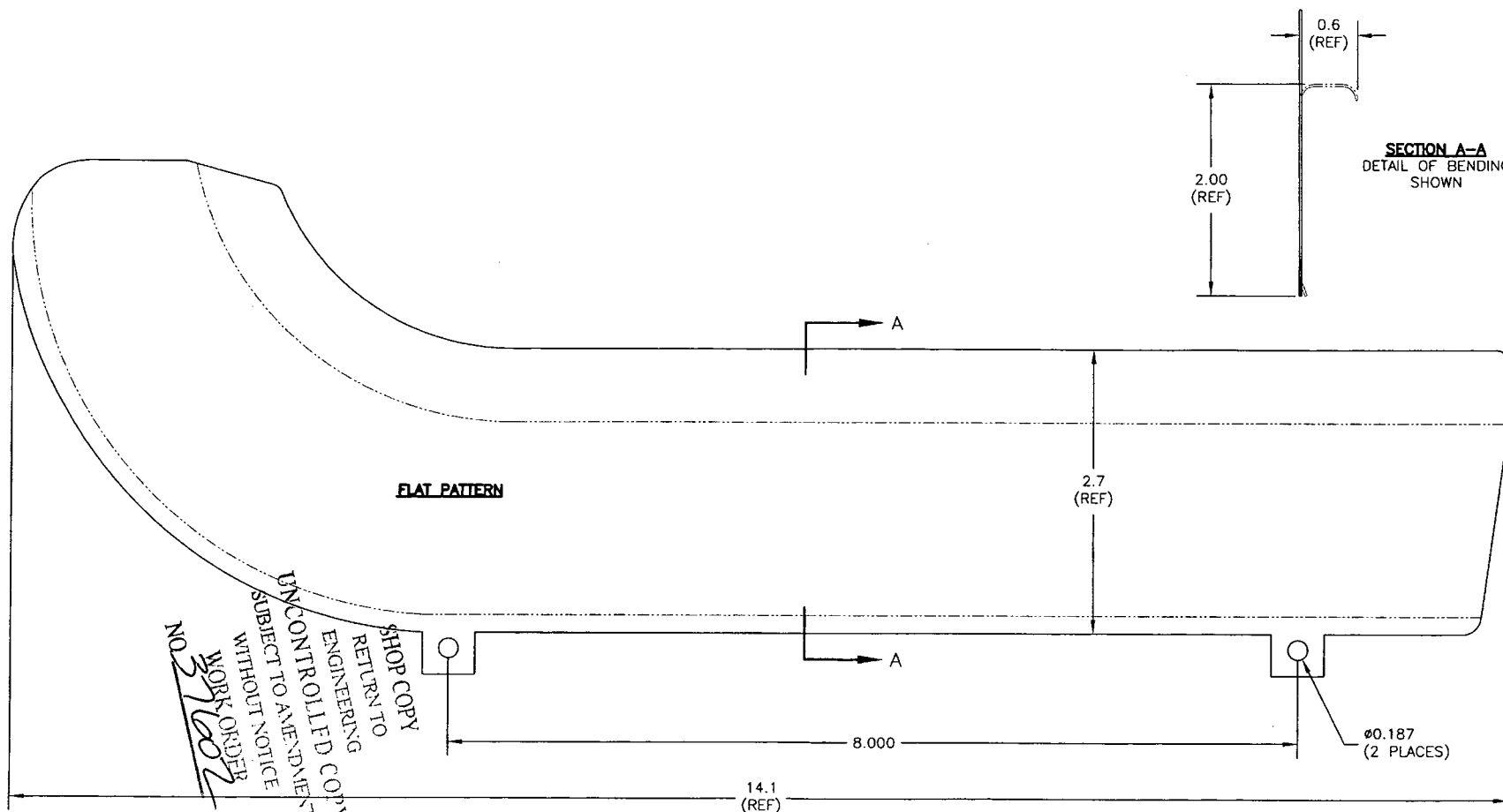
QTY REQUIRED			PART NO.	DESCRIPTION
-041	-043	-045		
X			D206-555-041	SCUFF PLATE KIT 206 A/B
	X		D206-555-043	SCUFF PLATE KIT 206 L/L1/L3
		X	D206-555-045	SCUFF PLATE KIT 206 L/L1/L3, EXECUTIVE INTERIOR
1			D206-555-001	FORWARD LH
1			D206-555-002	FORWARD RH
1			D206-555-003	AFT LH
1			D206-555-004	AFT RH
	1		D206-555-005	FORWARD LH
	1		D206-555-006	FORWARD RH
	1	1	D206-555-007	AFT LH
	1	1	D206-555-009	AFT RH
		1	D206-555-011	FORWARD LH
		1	D206-555-012	FORWARD RH

RELEASED
67.11.08 *MP*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37602*

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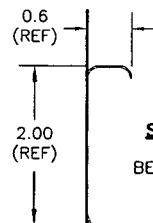
D206-555-001 (BEND IN DIRECTION SHOWN IN SECTION A-A)
D206-555-002 (BEND OPPOSITE)

NOTES

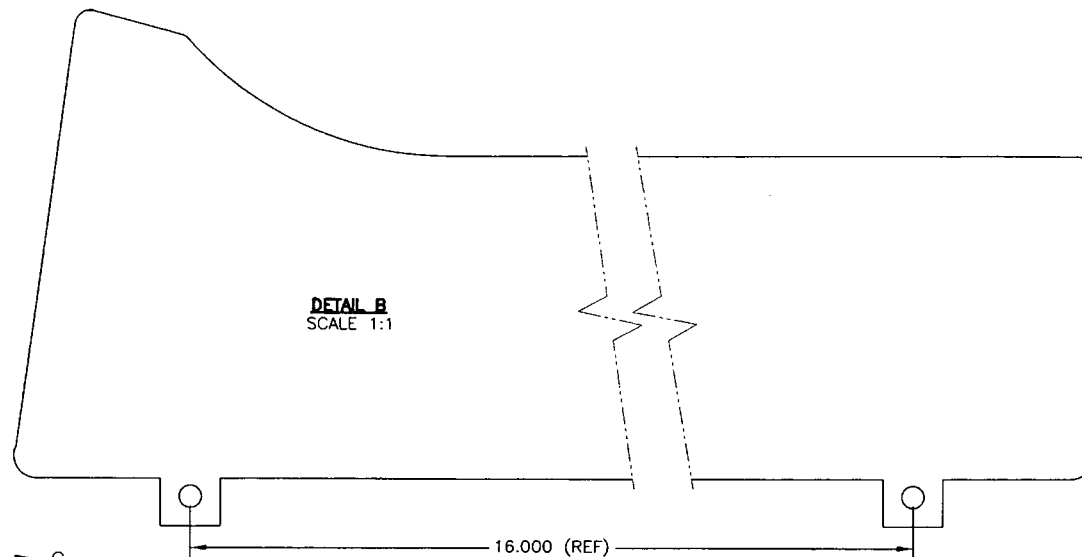
- 1) BEND PER M/F TEMPLATE D206-555-T1
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07-11-08

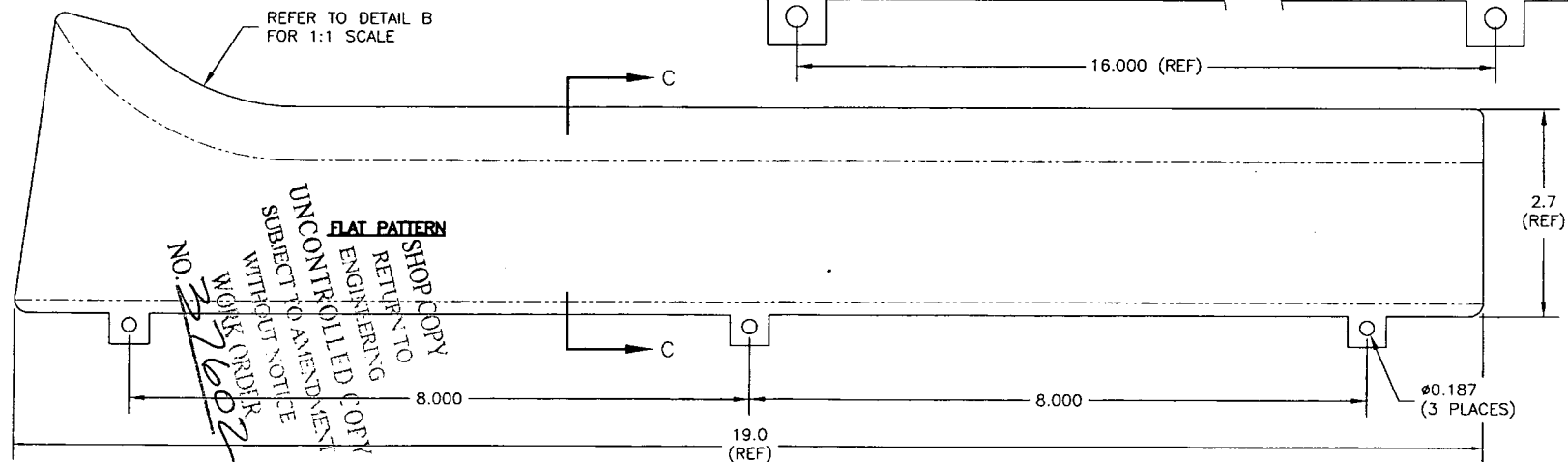
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CHECKED PH	APPROVED PH	DRAWING NO. D206-555	SHEET 2 OF 7
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	SCALE 1:1	



SECTION C-C
DETAIL OF
BENDING SHOWN



DETAIL B
SCALE 1:1

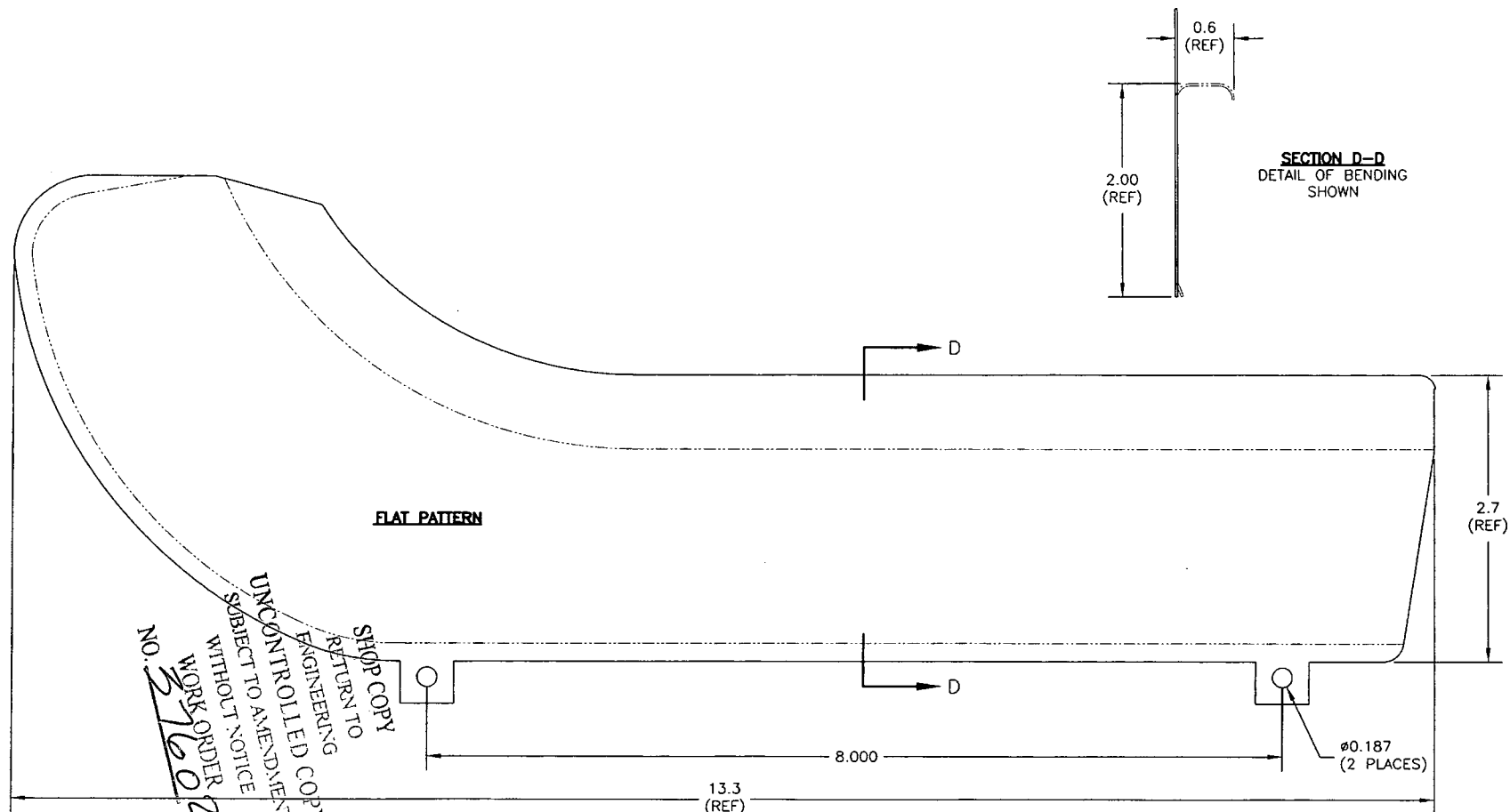


D206-555-003 (BEND IN DIRECTION SHOWN IN SECTION C-C)
D206-555-004 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T3
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY B	DART DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED PH	APPROVED H	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 3 OF 7 SCALE 2:3

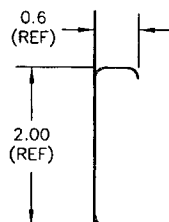


D206-555-005 (BEND IN DIRECTION SHOWN IN SECTION D-D)
D206-555-006 (BEND OPPOSITE)

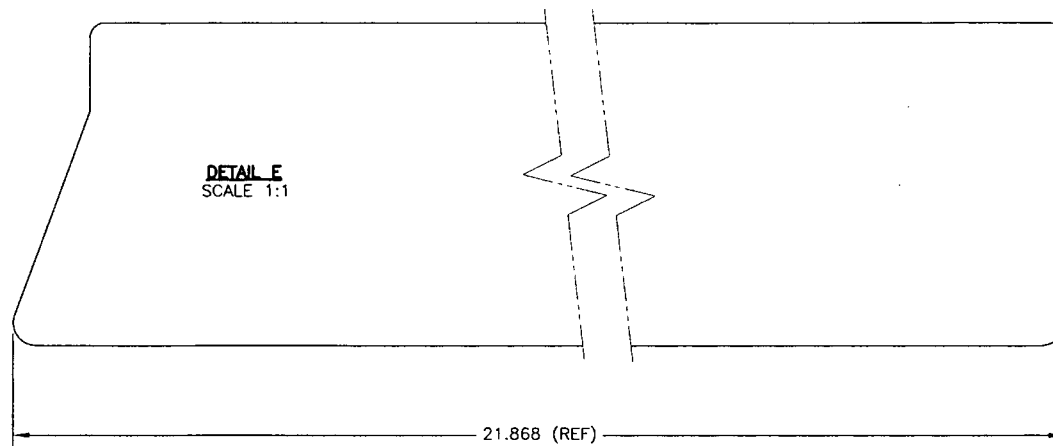
NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T5
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

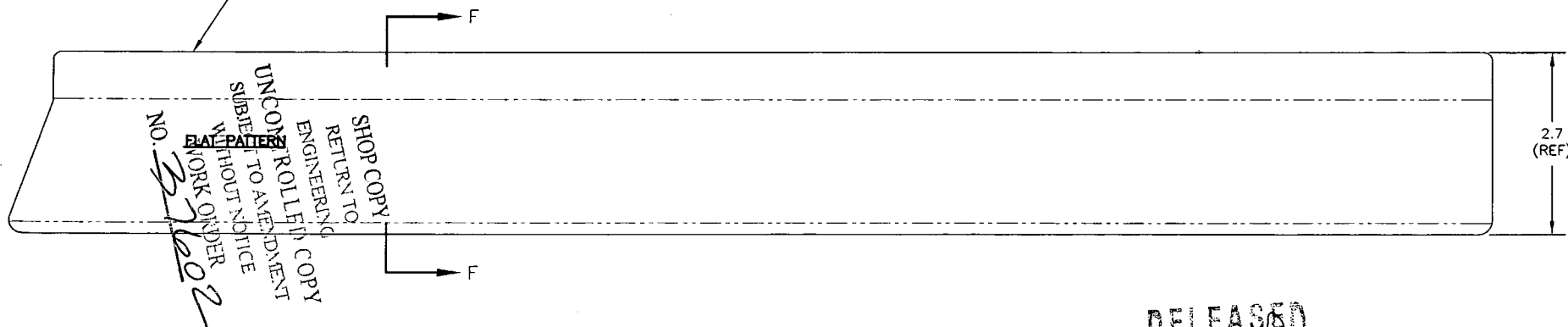
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CHECKED PH	APPROVED PH	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 4 OF 7 SCALE 1:1



SECTION F-F
DETAIL OF
BENDING SHOWN



REFER TO DETAIL E
FOR 1:1 SCALE



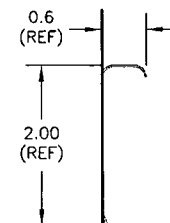
D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07-11-86

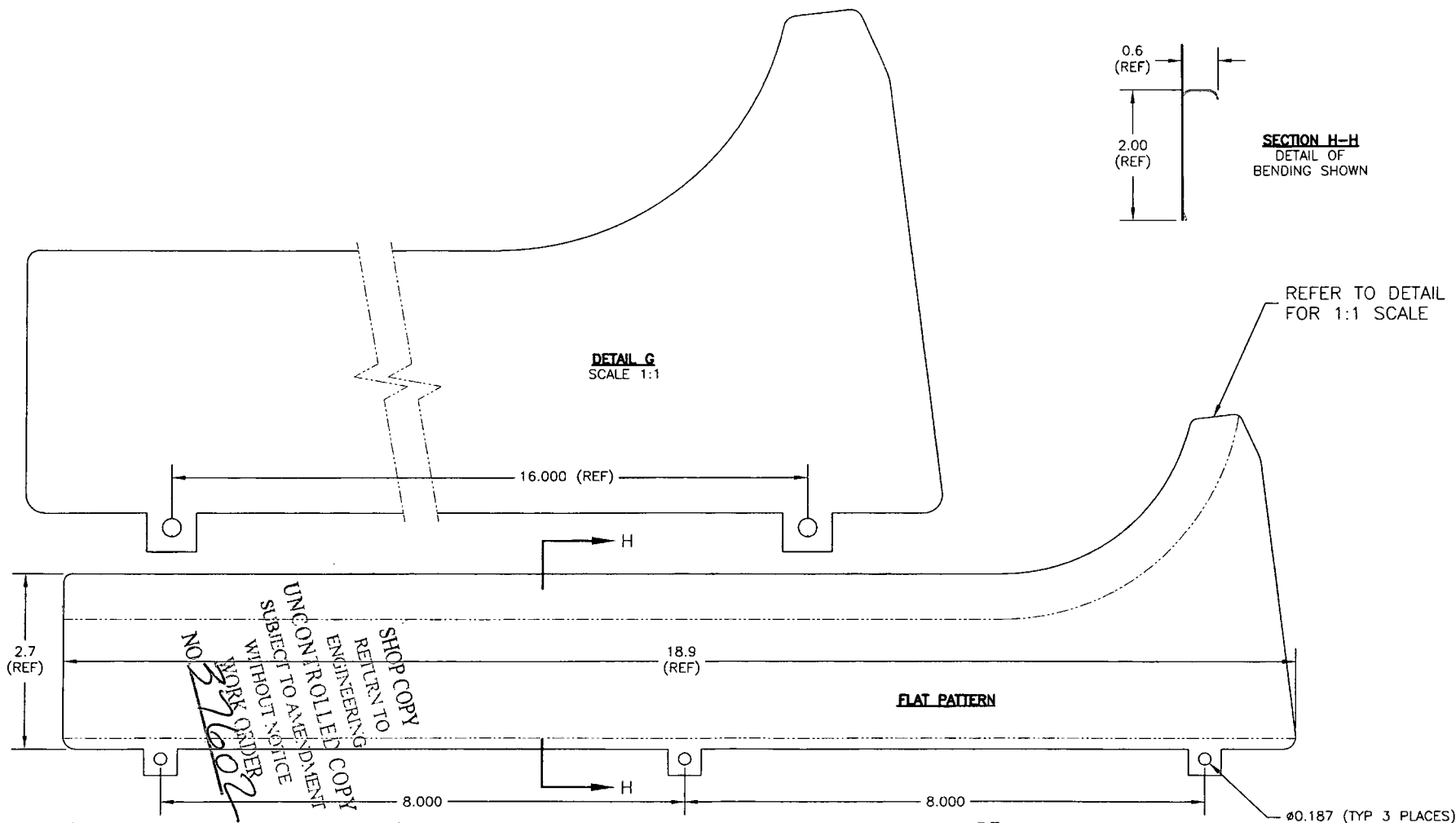
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CHECKED PH	APPROVED H	DRAWING NO. D206-555
DATE 06.09.01	TITLE DOOR SILL SCUFF PLATES	REV. C SHEET 5 OF 7 SCALE 2:3



SECTION H-H
DETAIL OF
BENDING SHOWN

REFER TO DETAIL G
FOR 1:1 SCALE

DETAIL G
SCALE 1:1



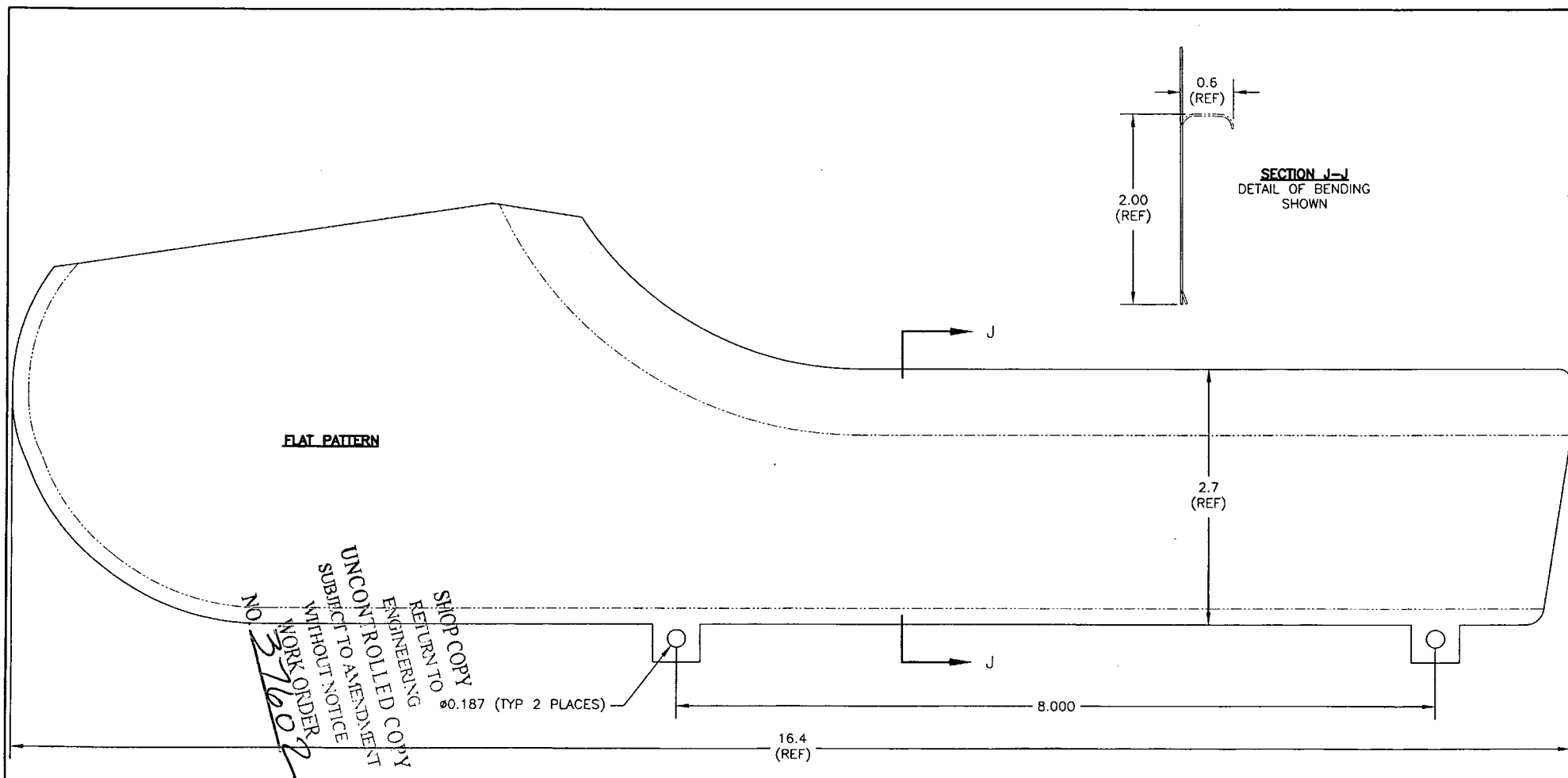
D206-555-009 (BEND IN DIRECTION SHOWN IN SECTION H-H)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T9
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

DESIGN JB	DRAWN BY JB	DART DART AEROSPACE LTD MARKESBURY, ONTARIO, CANADA	REV. C
CHECKED PH	APPROVED H	DRAWING NO. D206-555	SHEET 6 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 2:3



D206-555-011 (BEND IN DIRECTION SHOWN IN SECTION J-J)
D206-555-012 (BEND OPPOSITE)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T11
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF: DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH, NO SCRATCHES ON SURFACES
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. C
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	SHEET 7 OF 7
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SCALE 1:1

D206-555-007

☒ **First Article** ☐ **Prototype**

Measured by:	HB	Audited by:	Jo	Prototype Approval:	mf
Date:	8-3-05	Date:	08/03/05	Date:	14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	